

AMENDMENTS TO THE CLAIMS:

THE FOLLOWING LISTING OF CLAIMS WILL REPLACE ALL PRIOR VERSIONS, AND LISTINGS, OF CLAIMS IN THE APPLICATION:

1. (Previously Presented) An insertion-molded cylindrical article, comprising a cylindrical molded body having an inner surface, a mark of an injection gate opening positioned on said inner surface, and a barrel portion having an outer surface, and a sheet-shaped insert having an upper end; wherein said insert is bonded to said outer surface of said barrel portion, and wherein said mark is positioned at said inner surface of the cylindrical molded body while being inwardly apart from said upper end of said insert in an axial direction and at a position corresponding to a position on said inner surface that is covered by said insert.
2. (Previously Presented) The insertion-molded cylindrical article set forth in claim 1, further comprising a gap on said outer surface positioned between opposed ends of said insert and not covered by said insert, wherein said mark of the injection gate opening is not located in said gap.
3. (Previously Presented) A method for making an insertion-molded cylindrical article using an insertion injection molding mold, said insertion-molded article comprising a cylindrical molded body having a molded body inner surface, a bottom portion, a barrel portion having an outer surface, and an insert having an upper end; said insertion injection molding mold comprising an outer mold unit having an inner surface and a pull-out mold unit and defining a core-inserting space therein, a core having an injection gate opening and shaped to be inserted and fitted into the outer molding unit, and a molding cavity defined between said outer mold unit and said core inside the injection molding mold,

said method comprising
 fitting, attaching and holding said insert along said inner surface of the outer
 molding unit in said molding cavity,
 injecting a molten resin through said injection gate opening toward said
 molded body inner surface at a position inwardly apart from said upper end of the insert in an
 axial direction and at a position corresponding to a position on said molded body inner
 surface that is covered by said insert, and
 curing and forming the cylindrical molded body while pushing the insert onto
 the inner surface of the outer molding unit with the molten resin;

 wherein said insert is integrally bonded to said outer surface of said barrel
portion of the cylindrical molded body.

4. (Previously Presented) The method set forth in claim 3, wherein said
insertion-molded article further comprises a gap on said outer surface of said barrel portion
positioned between opposed ends of said insert and not covered by said insert;

 wherein the insert is fitted, attached and held along said inner surface of the
molding cavity, and

 wherein the molten resin is not injected toward said gap.

5. (Previously Presented) The method set forth in claim 3, wherein a knock-out
pin is provided in the core, said method further comprising:

 upwardly pulling out the pull-out mold unit of the outer mold unit after the
insertion molding,

 cutting a connection between the cured resin inside the injection gate opening
and the cylindrical molded body by raising the knock-out pin, and

 removing the cylindrical article from the core by pushing the bottom portion of
the cylindrical molded body.

6. (Currently Amended) The method set forth in claim 3, wherein the insert is fitted, attached and held in a cylindrical shape along the inner surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert, said contact frictional force formed by partially fitting the insert in the cylindrical shape into the outer mold unit in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, and forwardly moving the core into the outer mold unit.

7. (Withdrawn) An apparatus for molding an insert-bonded cylindrical article comprising a cylindrical molded body and an insert integrally bonded to an outer peripheral surface of a barrel body of the cylindrical molded body, said apparatus comprising an outer mold unit having a cylindrical pull-out mold unit and defining a core-inserting space therein, a core to be inserted into the core-inserting space of the outer molding unit from one end thereof and to define a molding cavity between an inner peripheral surface of the core-molding space, and a releasing tool for releasing the shaped insert-bonded cylindrical article from the mold, the outer molding unit comprising a barrel portion-molding mold unit having said core-inserting space and an end portion-molding mold unit to be engaged with the barrel portion-molding mold unit at the other end of the outer mold unit, having a molten resin-injecting opening and being capable of moving outside from an end portion, and the core having a gate hole communicating with the molten resin-injecting opening at one end, having the other end that is at the outer peripheral surface of the core and axially inwardly from the end portions of the insert fitted along the outer peripheral surface of the core-inserting space and at an inner portion of the insert located inwardly from both width sides of the insert.

8. (Withdrawn) The molding apparatus set forth in claim 7, wherein the insert-bonded cylindrical article has a mouth portion, and the end portion-molding mold unit

comprises a molding mold end disc, as the pull-out mold unit, having a molten resin-injecting opening, and a mouth portion mold unit to be engaged with the mold end disc and form the mouth portion of the cylindrical article.

9. (Withdrawn) The molding apparatus set forth in claim 7, wherein radial molten resin runner grooves are formed at a joint face between one end of the core and the end portion-molding mold unit, and one end opening of the gate hole is to communicate with end portions of the running grooves.

10. (Withdrawn) The apparatus set forth in claim 7, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold.

11. (Withdrawn) The apparatus set forth in claim 7, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injecting gate opening and the cylindrical molded body is cut by raising the knock-out pin.

12. (Previously Presented) The method set forth in claim 4, wherein a knock-out pin is provided in the core, said method further comprising:

upwardly pulling out the pull-out mold unit of the outer core mold unit after the injection molding,

cutting a connection between the cured resin inside the injection gate opening and the cylindrical molded body by raising the knock-out pin, and

removing the cylindrical article from the core by pushing the bottom portion of the gate cylindrical molded body.

13. (Currently Amended) The method set forth in claim 4, wherein the insert is fitted, attached and held in a cylindrical shape along the inner surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert,

said contact frictional force formed by partially fitting the insert in the cylindrical shape into the outer mold unit in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, and forwardly moving the core into the outer mold unit.

14. (Currently Amended) The method set forth in claim 5, wherein the insert is fitted, attached and held in a cylindrical shape along the inner surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert, said contact frictional force formed by partially fitting the insert in the cylindrical shape into the outer mold unit in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, and forwardly moving the core into the outer mold unit.

15. (Withdrawn) The molding apparatus set forth in claim 8, wherein radial molten resin runner grooves are formed at a joint face between one end of the core and the end portion-molding mold unit, and one end opening of the gate hole is to communicate with end portions of the running grooves.

16. (Withdrawn) The apparatus set forth in claim 8, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold.

17. (Withdrawn) The apparatus set forth in claim 9, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold.

18. (Withdrawn) The apparatus set forth in claim 8, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin.

19. (Withdrawn) The apparatus set forth in claim 9, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin.

20. (Withdrawn) The apparatus set forth in claim 10, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin.